CLAIMS

WHAT IS CLAIMED IS:

A water-based adhesive composition, comprising an admixture of:

- about 5 to about 80 wt% of an aqueous polyester Α. polyurethane \dispersion; and
- about 95 to about 20 wt% of an aqueous aliphatic В. polyurethane diapersion.
- The water-based adhesive composition of claim 1, 2. wherein said aqueous polyester polyurethane dispersion comprises from about 15 to about 25 wt% of said admixture, based on the total weight of said composition.
- The water-based adhesive composition of claim 1, 3. wherein said aqueous polyester polyurethane dispersion comprises from about 17 to about 23 wt% of said admixture, based on the total weight of said composition.

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- 4. The water-based adhesive composition of claim 1, wherein said aqueous aliphatic polyurethane dispersion comprises from about 85 to about 75 wt% of said admixture, based on the total weight of said composition.
- 5. The water-based adhesive composition of claim 1,
 wherein said aqueous aliphatic polyurethane dispersion
 comprises from about 83 to about 78 wt% of said
 admixture, based on the total weight of said
 composition.
- 6. The water-based adhesive composition of claim 1, further comprising about 0.005 to about 2 wt% of one or more additives selected from the group consisting of film-forming agents, slip agents, flow agents, adhesion promotors tackifiers, surfactants, defoamers, decorative components, and combinations thereof.
- 7. The water-based adhesive composition of claim 6, wherein said adhesion promotor is an epoxylated silane adhesion promotor.

- 8. The water-based adhesive composition of claim 7, wherein said epoxylated silane adhesion promotor is γ -glycidoxypropyltrimethoxysilane.
- 5 9. The water-based adhesive composition of claim 1, further comprising from about 0.5 wt% to about 25 wt% of a solvent.
 - 10. The water-based adhesive composition of claim 9, wherein said solvent is selected from the group consisting of water, N-methylpyrrolidone, butylcarbitol, 2-butoxyethanol, 2,2-butoxyethanol, and combinations thereof.
 - 11. A water-based adhesive composition, comprising an admixture of:
 - A. about 17.5 to about 22.5 wt% of an aqueous polyester polyurethane dispersion;
 - B. about 82.5 to about 77.5 wt% of an aqueous aliphatic polyurethane dispersion;
 - C. about 0.005 to about 2 wt% of one or more additives selected from the group consisting of film-forming agents, adhesion promotors,

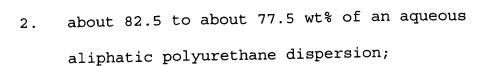
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tackifiers surfactants, defoamers, decorative components, and combinations thereof; and

- D. about 0.5 to about 25 wt% of a solvent selected from the group consisting of water, N-methylpyrrolidone, butylcarbitol, 2-butoxyethanol, 2,2-butoxyethanol, and combinations thereof.
- 12. The water-based adhesive composition of claim 11, wherein said adhesion promotor is an epoxylated silane adhesion promotor agent.
- 13. The water-based adhesive composition of claim 12, wherein said epoxylated silane adhesion promotor is γ -glycidoxypropyltrimethoxysilane.
- 14. A method of adhering a workpiece to a substrate, comprising the steps of:
- A. applying a water-based adhesive composition to a substrate, said water-based adhesive composition comprising an admixture of:
 - 1. about 17.5 to about 22.5 wt% of an aqueous polyester polyurethane dispersion;

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- about 0.005 to about 2 wt% of one or more additives selected from the group consisting of film-forming agents, adhesion promotors, tackifiers, surfactants, decorative components, defoamers, and combinations thereof; and
- 4. about 0.5 to about 25 wt% of a solvent selected from the group consisting of water, N-methylpyrrolidone, butylcarbitol, 2-butoxyethanol, 2,2-butoxyethoxyethanol, and combinations thereof;
- B. curing said water-based adhesive onto said substrate; and
- C. adhering said workpiece onto said substrate.
- 15. The method of claim 14, wherein said adhesion promotor is an epoxylated silane adhesion promotor.
- 16. The method of claim 14, wherein said epoxylated silane adhesion promotor is γ -glycidoxypropyltrimethoxysilane.

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- 17. The method of claim 14, wherein said applying step is accomplished by draw down rod, doctor blading, gravure roll, spraying, or dipping.
- 5 18. The method of claim 14, wherein said curing step occurs at between 200 and 500°F for between 2 and 50 seconds.
 - 19. The method of claim 14, wherein said adhering step comprises pressing said substrate and said workpiece together at about 100 psi for approximately 5-60 seconds.

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20. The method of claim 14, wherein said substrate is selected from the group consisting of stainless steel, aluminum, copper, iron, cold rolled steel, phosphatized steel, primer-coated steel, polyester reinforced fiber glass, butyrates, PVC, ABS, injection molded urethanes, polystyrenes, polyimides, polyamides, and combinations thereof.

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